

13

Date: Wednesday, 2/15/2006 3:46:15 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)  
 Job Number : 25833  
 Estimate Number : 10534  
 P.O. Number : N/A Part Number : D2574  
 This Issue : 2/15/2006 S.O. No. : N/A Drawing Number : D2574 REV E  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E  
 Previous Run : 25620 Material : N/A  
 Due Date : 3/15/2006 Qty: 10 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : 06.02.16  
 Comment : Est Rev: 1 As Per RevE 06-01-27 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: 823940

S.G.

06/02/26

1d

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No: 35833 Double check by: SA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

Ep 06/03/04

S.G. 06/02/27

1b

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

Ep 06/03/04

11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ep 06/03/04

11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 25833

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 06-03-04

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06-03-06

11

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-03-06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M 06 03 06 (11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST480

C 206103107 11

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06103108 (11)

Job Completion



W 06-03-07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 06/03/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 25833
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.745	1.746	1.745	1.747		
C	3.495	3.505		3.497	3.497	3.496	3.497		
D	1.745	1.755		1.745	1.746	1.745	1.747		
E	7.990	8.010		8.004	8.004	8.005	8.006		
F	0.490	0.510		0.501	0.499	0.499	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.499	0.499	0.498		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.566	0.567	0.566	0.565		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.368	1.369		
N	2.495	2.505		2.496	2.496	2.497	2.497		
O	4.119	4.129		4.121	4.121	4.123	4.123		
P	0.115	0.135		0.123	0.123	0.121	0.123		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.250	0.248	0.250	0.251		
S	0.115	0.135		0.126	0.130	0.131	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.280	3.230	3.230	3.230		
V	0.230	0.250		0.237	0.237	0.242	0.240		
W	0.115	0.135		0.125	0.125	0.125	0.127		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.366	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.625	0.625	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.247	0.247	0.245		
AE	1.500	1.520		1.515	1.510	1.510	1.509		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.253	0.254	0.251		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	CP
Date:	06/03/21

Audited by:	JL
Date:	06.03.09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25833</b>
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				1	2	3	4		
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B	1.745	1.755		1.749	1.749	1.749	1.748		
C	3.495	3.505		3.499	3.498	3.499	3.501		
D	1.745	1.755		1.749	1.749	1.749	1.748		
E	7.990	8.010		8.003	8.002	8.003	8.004		
F	0.490	0.510		0.500	0.499	0.501	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.502	0.500	0.500		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.568	0.567	0.568	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.369	1.368	1.369	1.369		
N	2.495	2.505		2.500	2.499	2.498	2.499		
O	4.119	4.129		4.124	4.123	4.122	4.122		
P	0.115	0.135		0.125	0.127	0.130	0.130		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.250	0.249	0.249	0.249		
S	0.115	0.135		0.125	0.124	0.128	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.221	3.221	3.221		
V	0.230	0.250		0.240	0.244	0.241	0.242		
W	0.115	0.135		0.127	0.129	0.128	0.131		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.631	0.632	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.255	0.254	0.254	0.255		
AE	1.500	1.520		1.508	1.507	1.508	1.509		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.267	0.269		
AH	0.240	0.260		0.251	0.247	0.248	0.248		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G.
Date:	06/03/02

Audited by:	J.L.
Date:	06.03.04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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E	7.990	8.010		8.004	8.004	8.004			
F	0.490	0.510		0.500	0.496	0.498			
G	0.257	0.262	DT8683	0.257	0.257	0.257			
H	0.375	0.380	DT8684	0.375	0.375	0.375			
I	0.490	0.510		0.499	0.502	0.500			
J	1.174	1.184		1.177	1.177	1.179			
K	0.558	0.578		0.568	0.567	0.568			
L	1.174	1.184		1.177	1.177	1.179			
M	1.365	1.375		1.378	1.368	1.369			
N	2.495	2.505		2.499	2.502	2.502			
O	4.119	4.129		4.122	4.121	4.123			
P	0.115	0.135		0.130	0.123	0.124			
Q	0.115	0.135		0.138	0.130	0.130			
R	0.240	0.260		0.249	0.254	0.252			
S	0.115	0.135		0.120	0.129	0.131			
T	0.178	0.198		0.188	0.188	0.188			
U	3.210	3.250		3.224	3.230	3.230			
V	0.230	0.250		0.240	0.237	0.241			
W	0.115	0.135		0.127	0.126	0.130			
X	0.307	0.312		0.310	0.310	0.310			
Y	0.760	0.765		0.760	0.760	0.760			
Z	0.352	0.372		0.360	0.360	0.360			
AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.629	0.625	0.626			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.249	0.250	0.250			
AE	1.500	1.520		1.512	1.509	1.509			
AF	0.115	0.135		0.130	0.130	0.130			
AG	0.240	0.280		0.244	0.260	0.260			
AH	0.240	0.260		0.250	0.252	0.252			
AI	2.000	2.020		N/A	N/A	N/A			
AJ	0.023	0.043		0.030	0.030	0.030			
Accept/Reject									

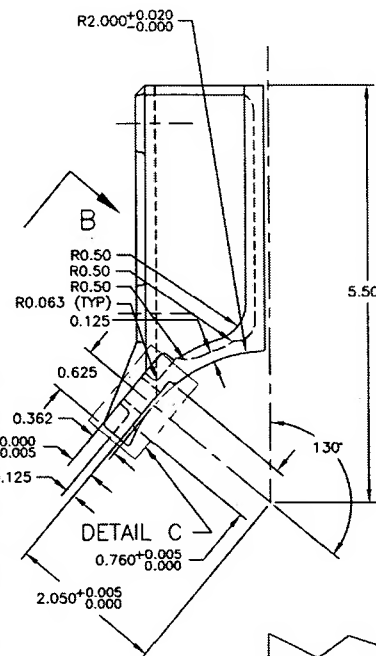
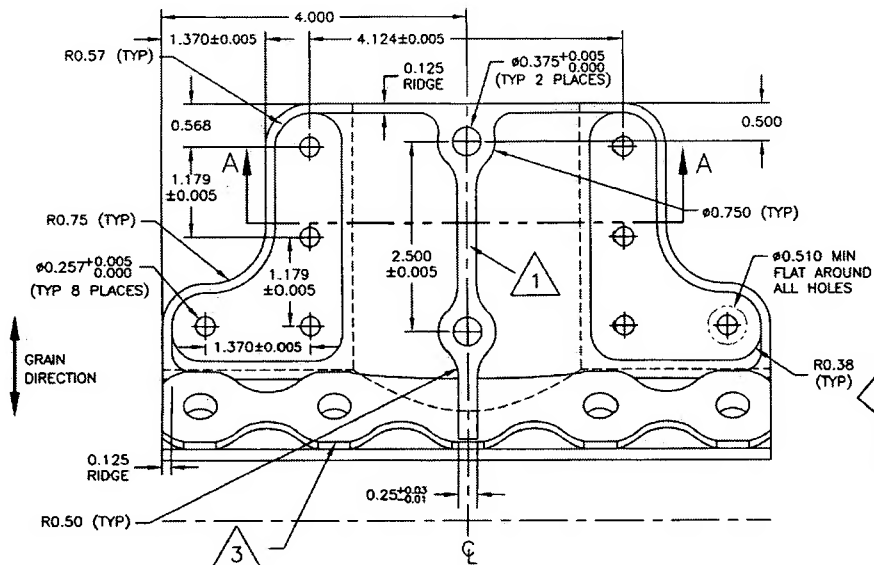
Measured by:	<b>S-G/</b>	<b>EP</b>
Date:	<b>06/03/03</b>	<b>06/03/04</b>

Audited by:	<b>JL</b>
Date:	<b>06-03-04</b>

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A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
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RELEASED

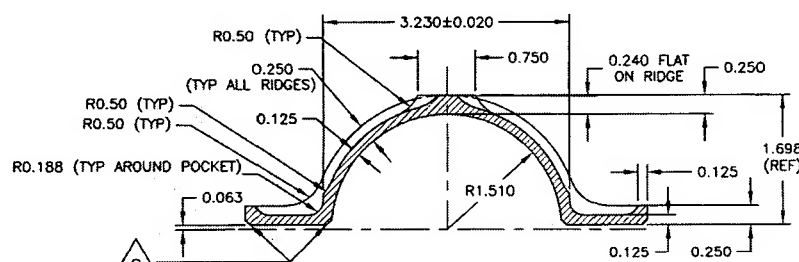
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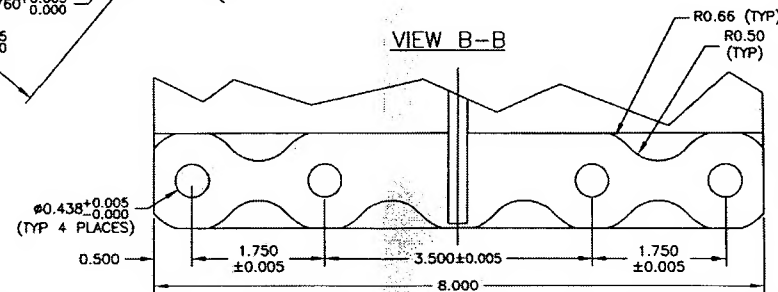
# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

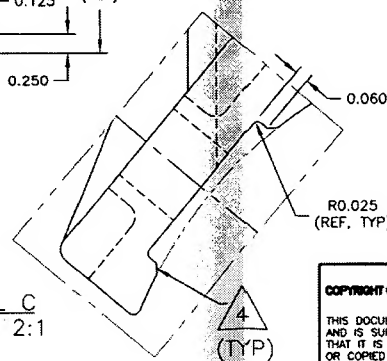
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



SECTION A-A



VIEW B-B



DETAIL C  
SCALE 2:1

NO. 25833  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

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